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**Bradfield**

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(54) **METHOD AND ARRANGEMENT FOR COOLING CLAW-POLE ELECTRIC MACHINES**

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See application file for complete search history.

(75) Inventor: **Michael D. Bradfield**, Anderson, IN (US)

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(73) Assignee: **Remy Technologies, LLC**, Pendleton, IN (US)

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(\*) Notice: Subject to any disclaimer, the term of this patent is extended or adjusted under 35 U.S.C. 154(b) by 406 days.

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*Primary Examiner* — John K Kim

(74) *Attorney, Agent, or Firm* — Maginot, Moore & Beck LLP

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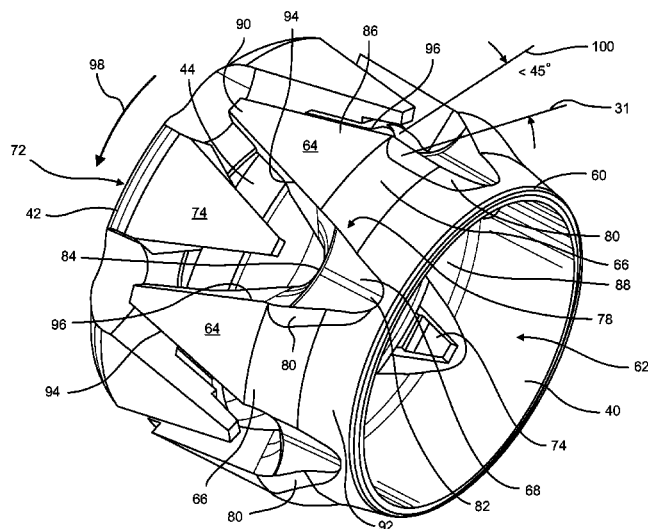
(57) **ABSTRACT**

An electric machine includes a stator and a rotor configured to rotate about an axis of rotation in a direction of angular rotation. The rotor includes a first claw-pole segment and an opposing second claw-pole segment. The first claw-pole segment includes a plurality of fingers extending from an end ring. Each finger includes a distal end and a proximal end with the proximal end fixed to the end ring. Each finger also includes an interior side and an exterior side with the exterior side facing the stator. A leading side and a trailing side are defined on each finger by the direction of angular rotation. A chamfer is formed on the exterior trailing side of each finger at the proximal end of the finger.

(58) **Field of Classification Search**

CPC ..... H02K 1/22; H02K 1/24; H02K 1/243; H02K 15/022; H02K 21/044; H02K 9/02; H02K 9/04; H02K 9/06

**18 Claims, 7 Drawing Sheets**



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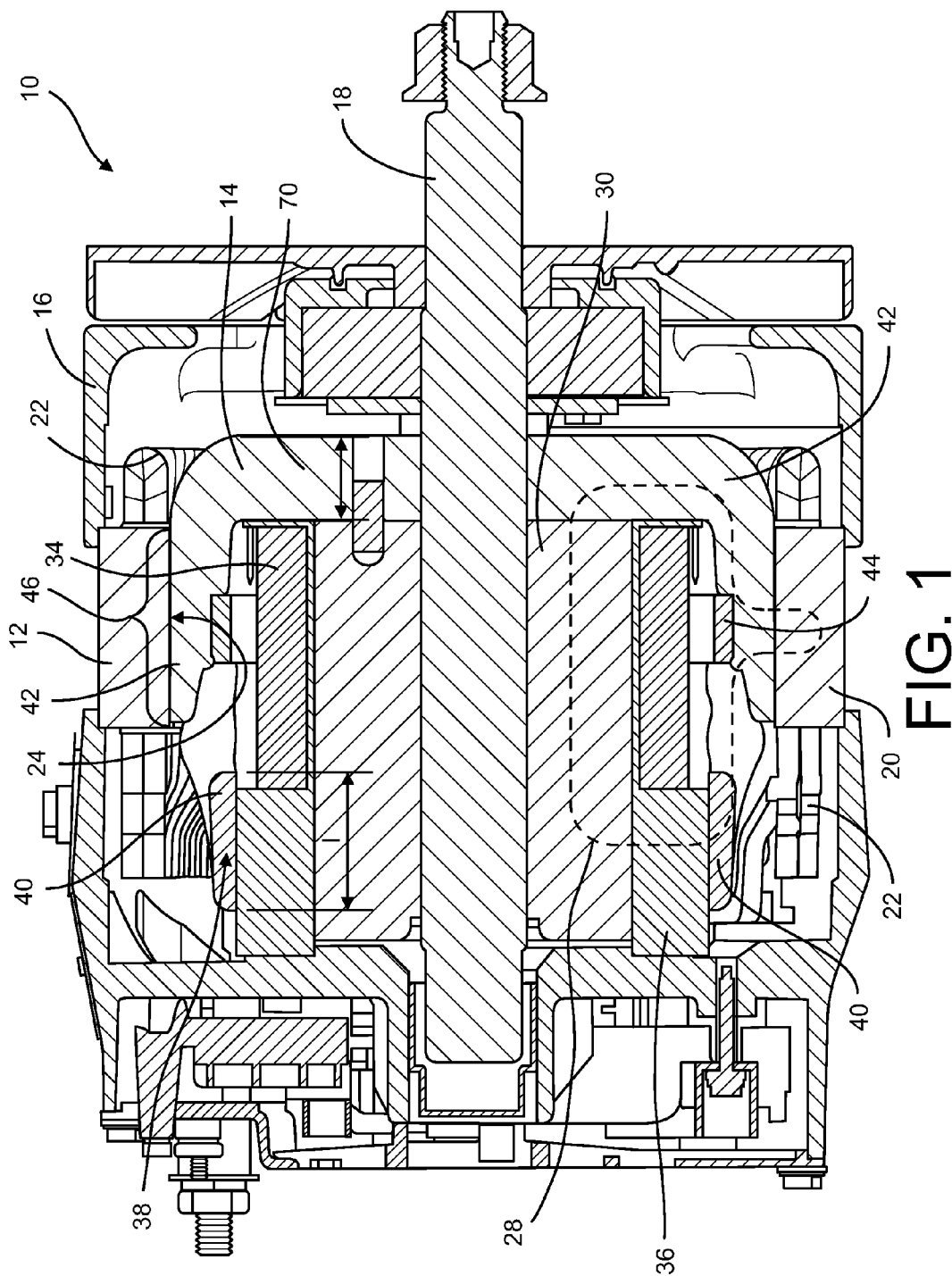
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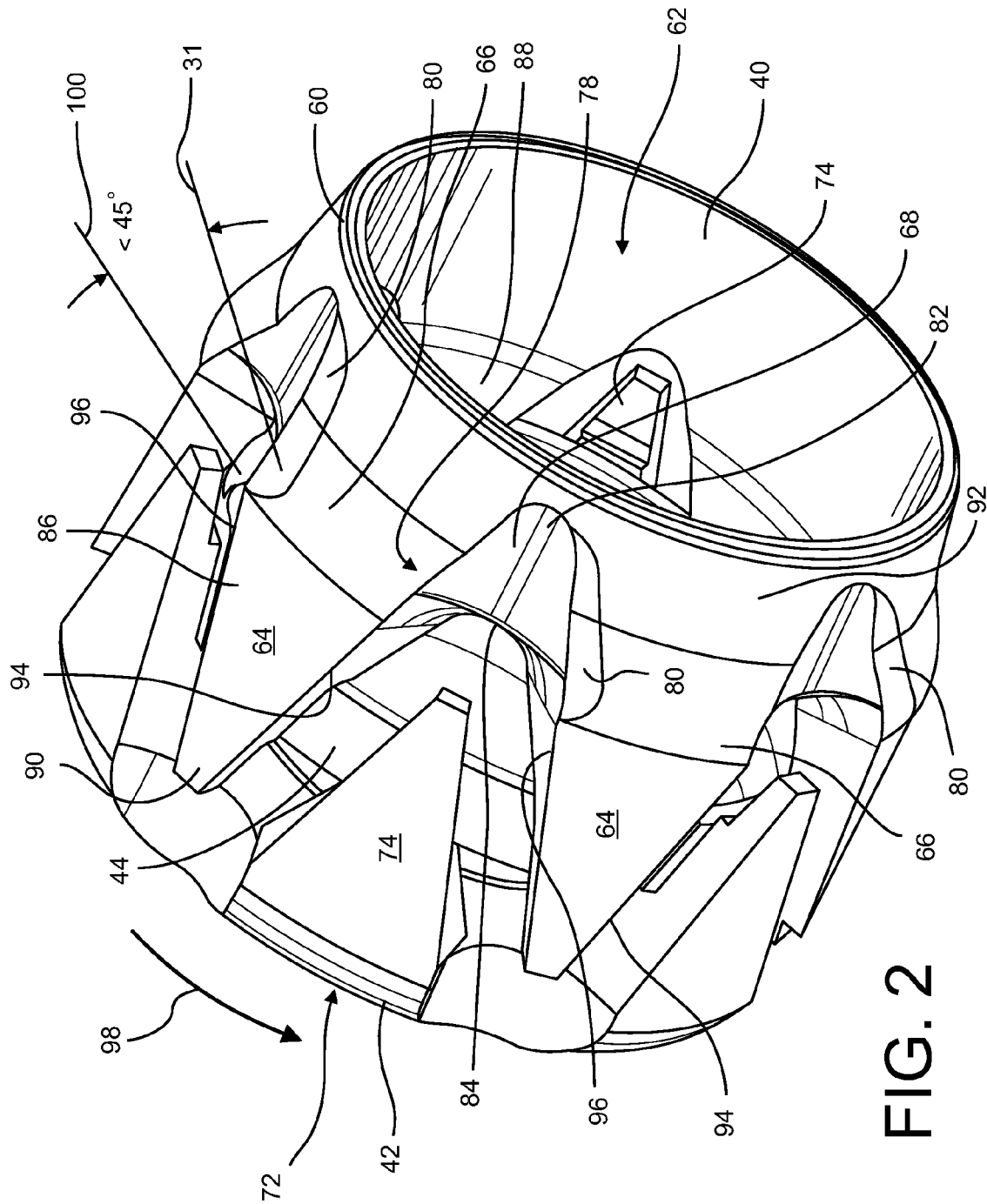
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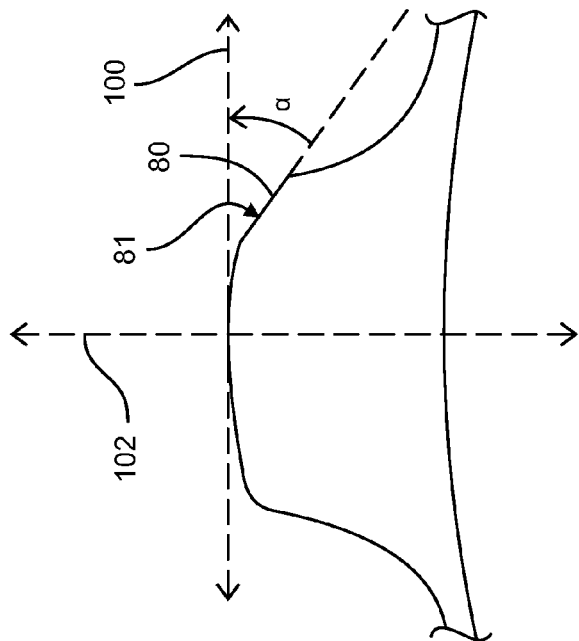
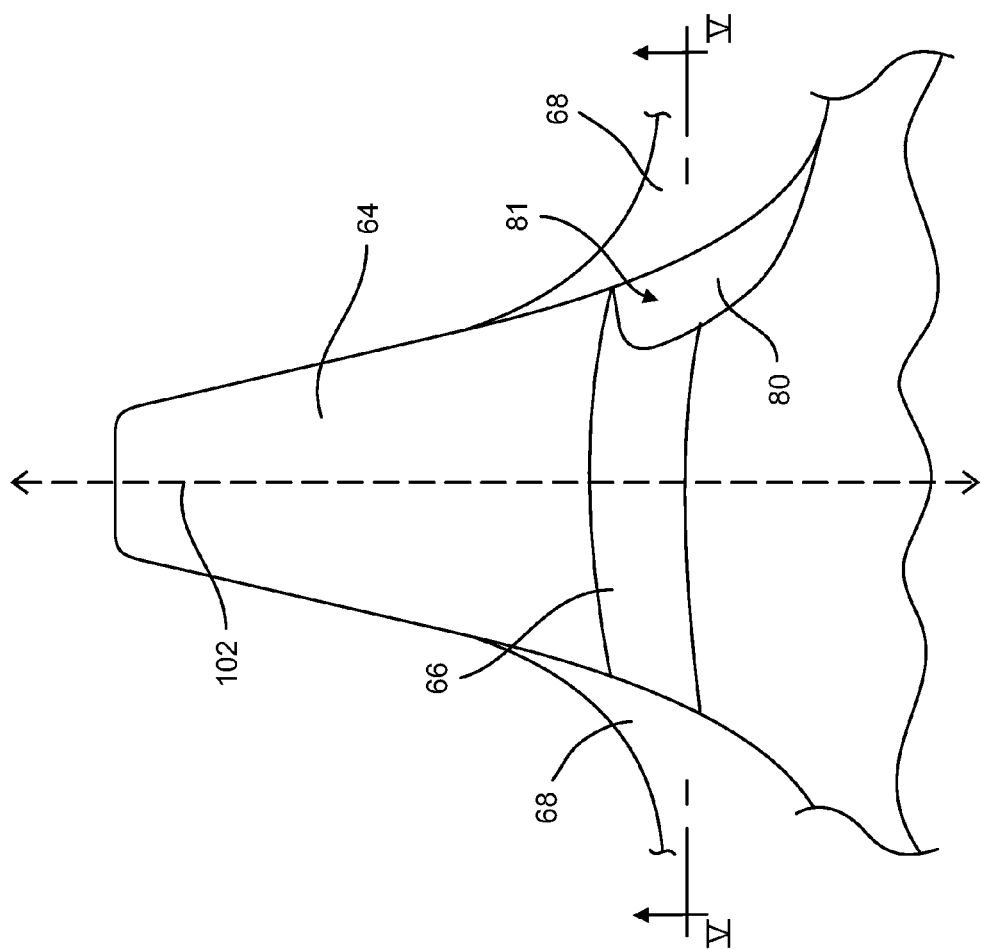
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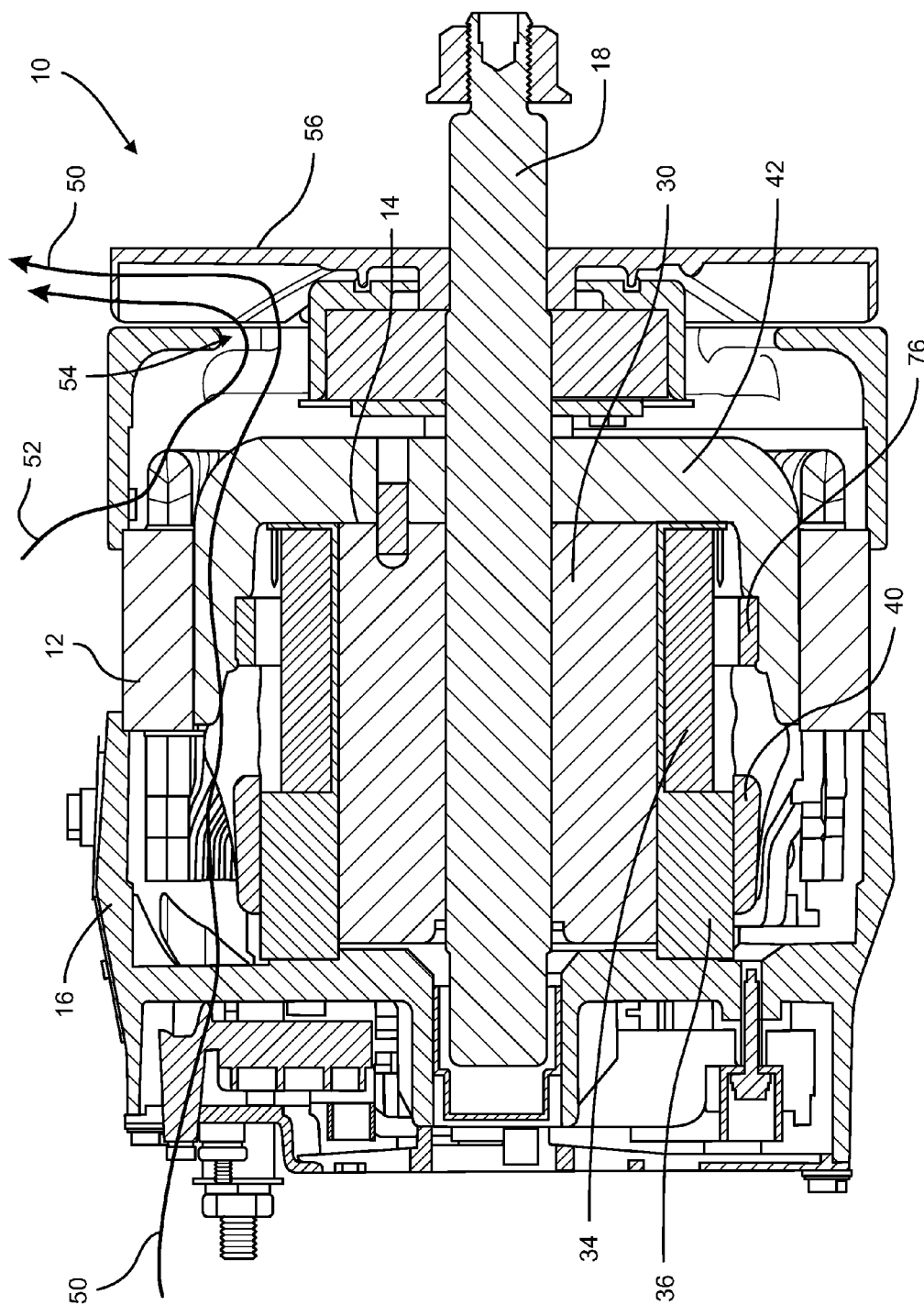


FIG. 5

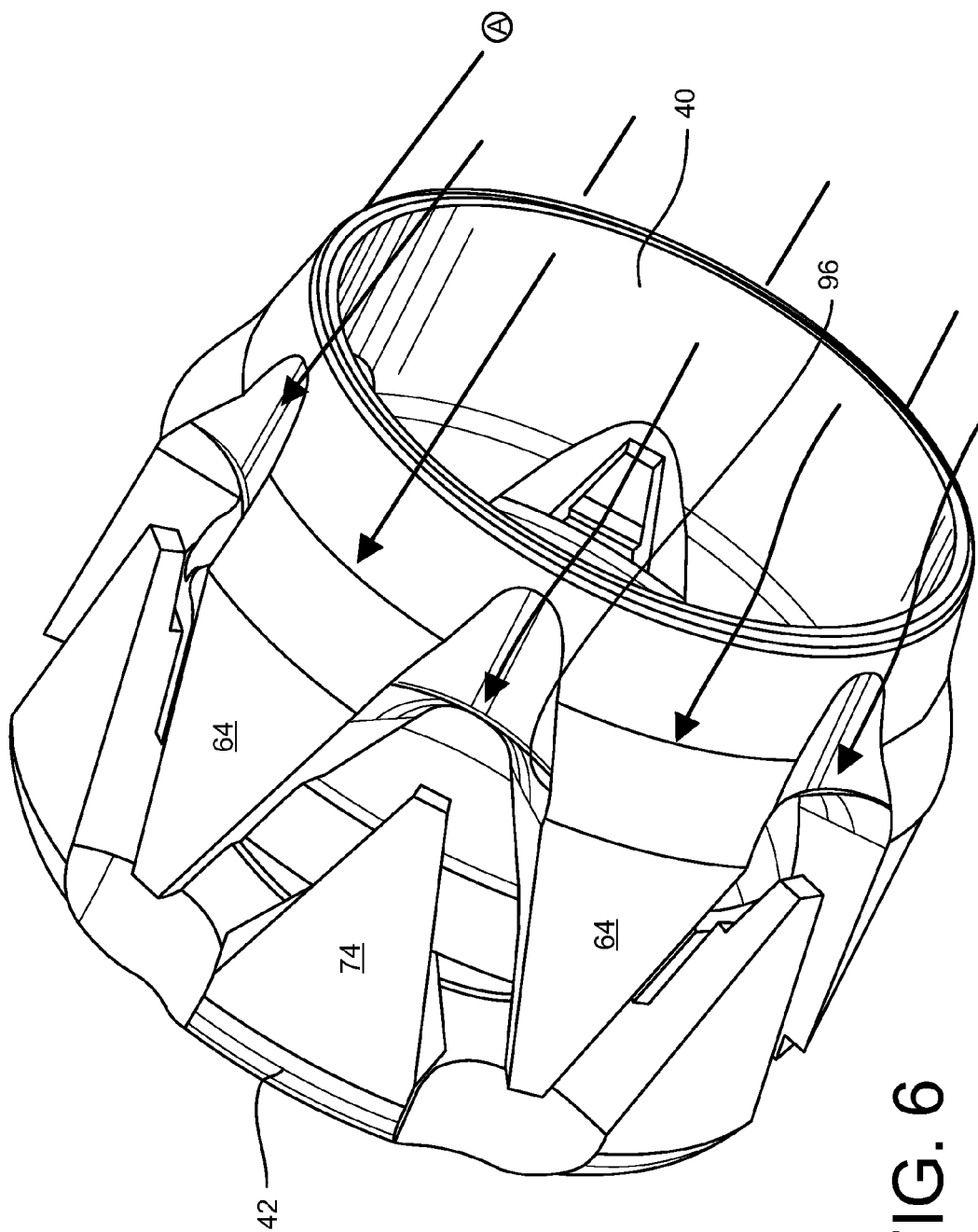
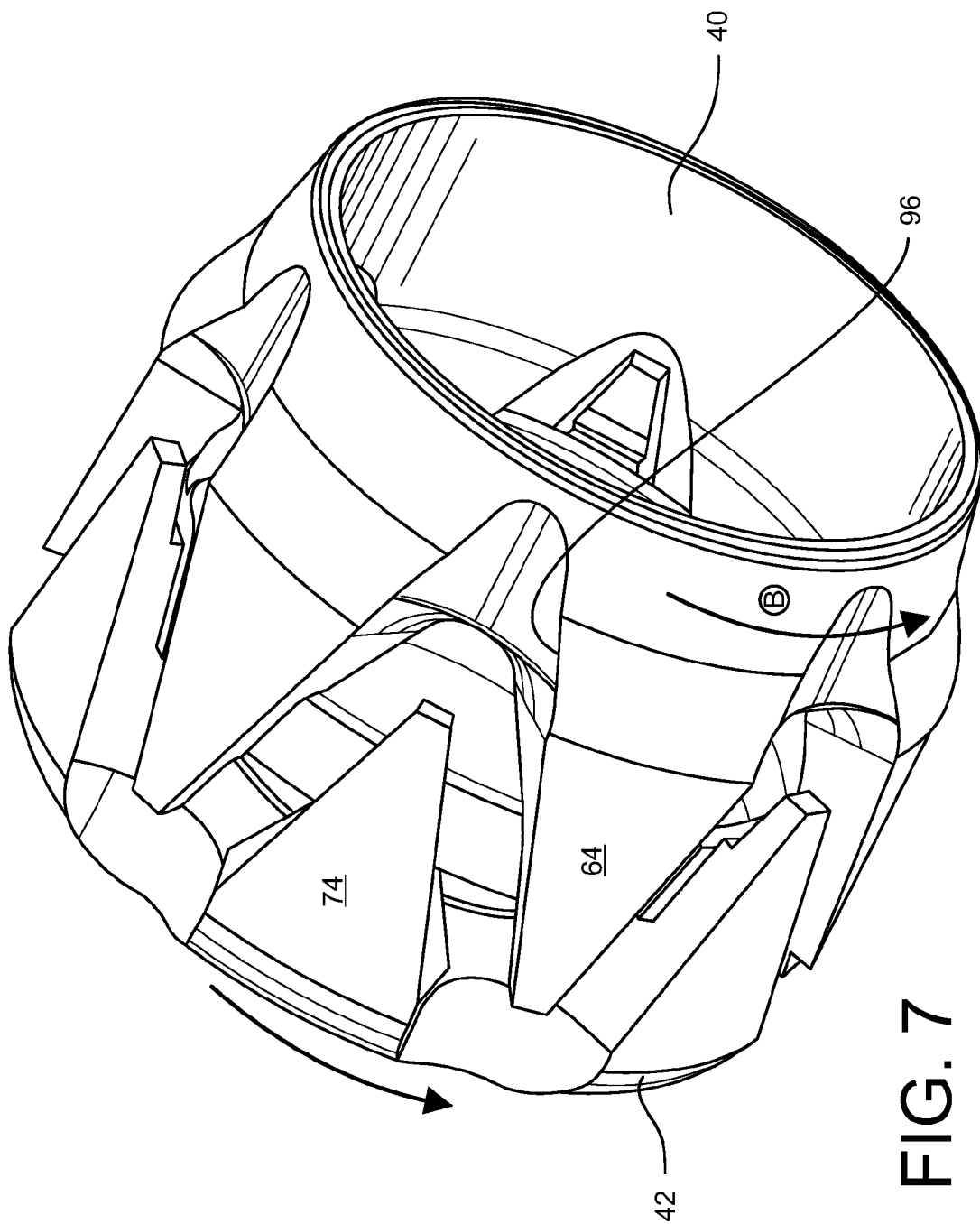


FIG. 6





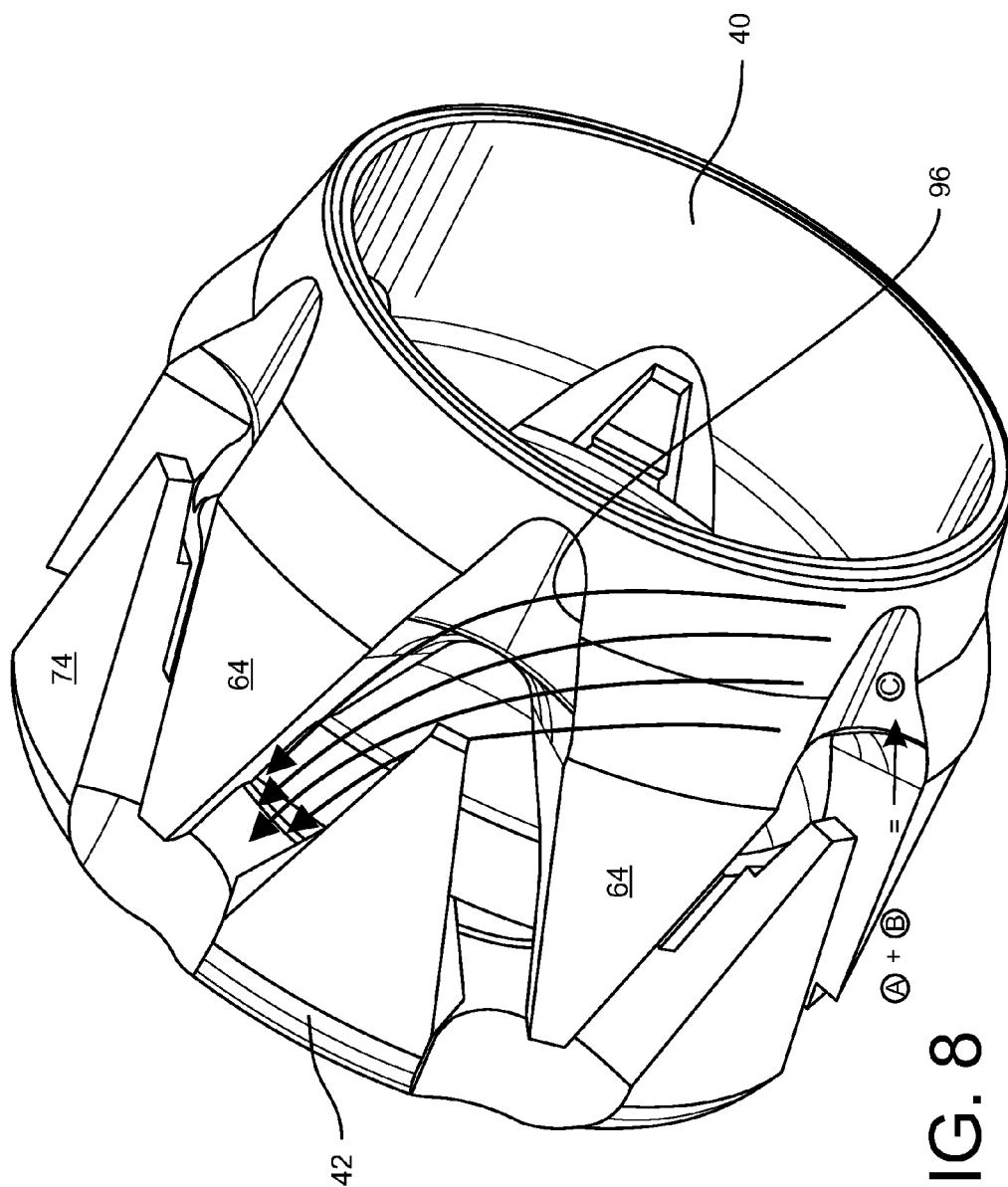


FIG. 8

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# METHOD AND ARRANGEMENT FOR COOLING CLAW-POLE ELECTRIC MACHINES

## CROSS-REFERENCE TO RELATED APPLICATIONS

This application is a division of U.S. patent application Ser. No. 12/716,549, filed Mar. 3, 2010, the contents of which are incorporated herein in their entirety.

## FIELD

This application relates to the field of electric machines, and particularly to cooling air flow arrangements in electric machines with claw-pole rotors.

## BACKGROUND

Alternators with claw-pole rotor arrangements (also known as "Lundell" type rotors) are commonly used in light-duty and heavy-duty vehicle applications. These alternators include a claw-pole rotor, a stator, a rectifier and a voltage regulator. The rotor is comprised of a field coil wound over an iron core and two opposing claw-pole iron segments surrounding the field coil. Each claw-pole iron segment typically includes six to nine fingers that are interlaced with the same number of fingers from the opposing claw-pole iron segment. When current flows through the field winding, one of the claw-pole segments provides a magnetic north segment and the other provides a magnetic south segment. Thus, the interlaced fingers of the claw-pole configuration result in a rotor with an alternating N pole, S pole arrangement.

Rotation of the rotor provides a rotating magnetic field. This rotating magnetic field induces a voltage in the windings positioned on the stator. The magnetic field in the stator rotates at the same speed, or synchronously, with the rotor field. The stator windings are connected to the rectifier, which converts the AC stator output to a DC output. At the same time, the voltage regulator monitors the system voltage and adjusts the output of the alternator by controlling the current through the field coil.

During operation of the claw-pole alternator, the alternator must be cooled to maintain the efficiency and performance of the alternator. The alternator is typically cooled by air flowing through the alternator, and it is generally desirable to direct as much cooling air as possible through the alternator. Air flow through the alternator is generally urged by a fan at the front of the alternator that acts to lower the air pressure within the alternator and draw cooling air into the alternator. Air flows from the rear of the alternator to the front of the alternator where it is expelled by the fan. The air expelled from the alternator is combined with the under hood airflow in the vehicle. This under hood vehicle airflow is generally from the front of the vehicle to the rear due substantially to the forward movement of the vehicle and the action of radiator cooling fans disposed at the front of the vehicle. Thus, the heated air expelled from the alternator, combines with the under hood airflow, and is carried back to the rear of the alternator where at least a portion of the heated air is re-circulated through the alternator.

In view of the foregoing, it would be desirable to provide an alternator arrangement having an improved airflow arrangement capable of directing an increased volume of cooling air through the alternator. It would also be desirable if such improved airflow arrangement could be accomplished simply without adding a significant number of additional compo-

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nents to the alternator. It would also be desirable if such improved airflow arrangement could be achieved without disturbing the arrangement of components within the alternator or significantly affecting electrical and magnetic performance of the alternator.

## SUMMARY

An electric machine comprises a stator and a rotor configured to rotate about an axis of rotation in a direction of angular rotation. The rotor includes a first claw-pole segment and an opposing second claw-pole segment. The first claw-pole segment includes a plurality of fingers extending from an end ring. Each finger includes a distal end and a proximal end with the proximal end fixed to the end ring. Each finger also includes an interior side and an exterior side with the exterior side facing the stator. A leading side and a trailing side are defined on each finger by the direction of angular rotation. An indentation is formed on the exterior trailing side of each finger at the proximal end of the finger. Because of this indentation, each finger is asymmetrical in shape along a plane of symmetry extending through an axial centerline of the finger and through the axis of rotation of the rotor.

In accordance with one embodiment of the disclosure, there is provided a method of cooling an alternator having a claw-pole rotor arrangement using a stream of air flowing through the alternator. The method comprises rotating the rotor arrangement in an angular direction of rotation. The method further comprises receiving a stream of air into a first end of the alternator such that the stream of air flows over an exterior surface of the claw pole arrangement. The stream of air then flows over a chamfer on a trailing edge of a finger of the claw-pole rotor arrangement. Next, the stream of air flows between fingers on opposing segments of the claw-pole rotor arrangement and over a field winding positioned on the interior of the claw-pole arrangement.

Pursuant to yet another embodiment of the disclosure, there is provided an alternator comprising a stator including a stator core and a plurality of stator windings. The alternator includes a rotor positioned within the stator, with the rotor configured to rotate about an axis of rotation in a direction of angular rotation. The rotor includes an open segment and a closed segment with a field winding positioned inside of the open segment and the closed segment. The open segment and the closed segment include a plurality of interlaced fingers with a web portion positioned between adjacent fingers on the open segment. Each finger on the open segment includes an interior side and an exterior side with the exterior side facing the stator and the interior side facing the field windings. A leading side and a trailing side of each finger are defined by the direction of angular rotation. A chamfer is formed on the exterior trailing side of each finger adjacent to the web portion.

The above described features and advantages, as well as others, will become more readily apparent to those of ordinary skill in the art by reference to the following detailed description and accompanying drawings. While it would be desirable to provide an alternator arrangement that provides one or more of these or other advantageous features, the teachings disclosed herein extend to those embodiments which fall within the scope of the appended claims, regardless of whether they accomplish one or more of the above-mentioned advantages.

## BRIEF DESCRIPTION OF THE DRAWINGS

FIG. 1 shows a cross-sectional view of one embodiment of a claw pole electric machine;

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FIG. 2 shows an isolated perspective view of two claw-pole segments of the electric machine of FIG. 1;

FIG. 3 shows a top view of a finger of one of the claw-pole segments of FIG. 2;

FIG. 4 shows a cross-sectional view of the finger of the claw-pole segment along line V-V of FIG. 3;

FIG. 5 shows a cross-sectional view of the claw pole electric machine of FIG. 1 illustrating an air stream through the electric machine;

FIG. 6 shows an isolated perspective view of two claw-pole segments of an electric machine illustrating an initial direction of air flow into the electric machine;

FIG. 7 shows the isolated perspective view of the two claw-pole segments of FIG. 6 illustrating the direction of angular rotation of the claw-pole segments during operation of the electric machine; and

FIG. 8 shows the isolated perspective view of the two claw-pole segments of FIG. 6 illustrating the direction of air flow relative to the claw-pole segments during operation of the electric machine.

### DESCRIPTION

With reference to FIG. 1, an electric machine is shown in the form of a claw-pole alternator 10. The alternator includes a stator 12 and a claw-pole rotor 14 positioned within a housing 16. The rotor is connected to a shaft 18. As is well known in the art, the shaft 18 is driven by a belt (not shown) during operation of the vehicle in which the alternator is mounted.

The stator 12 is stationary within the alternator housing 16. The stator 12 includes a stator core 20 and stator windings 22. The rotor 14 includes a plurality of teeth that extend radially inward from the outer diameter of the stator core. The stator windings 22 are retained by slots formed between the teeth of the stator core. The stator windings 22 may be formed by insulated copper wires that form coils that wrap around the stator core. The coils are separated into three distinct winding segments that provide a three-phase electrical output for the alternator 10.

The rotor 14 is rotatably positioned inside of the stator 12 within the alternator. The rotor 14 is separated from the stator 12 by an airgap 24 in an active airgap region 46 of the rotor. The rotor 14 includes an iron core 30, a field coil 34, and two claw-pole segments 40, 42. In the disclosed embodiment, the field coil 34 is wound around an iron spool 36, and the field coil 34 and spool 36 are stationary within the alternator housing 16. The first claw-pole segment 40 is positioned radially outward from the spool 36 and is separated from the spool 36 by an air gap 38. The first claw-pole segment 40 is connected to the second claw-pole segment 42 by a connection ring 44, and the second claw-pole segment 42 is secured to the shaft 18. The rotor core 30 is also secured to the second claw-pole segment 42 and the shaft 18. Accordingly, the iron core 30, the first claw-pole segment 40 and the second claw-pole segment 42 are all rotatable with the shaft 18 within the alternator housing 16.

FIG. 2 shows a perspective view of the first and second claw pole segments 40, 42 isolated from the remaining portions of the rotor 14. The first claw pole segment 40 is generally crown shaped with a circular end band or end ring 60. The cylindrical end ring 60 defines a generally open end portion 62, and thus this segment 40 is sometimes referred to as an "open segment". A plurality of fingers 64 extend from the end ring 60 with knuckle portions 66 positioned on the fingers 64. In the embodiment of FIG. 2, the knuckle portions

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66 are generally enlarged portions on the finger. In FIG. 2, the knuckles 66 provide a sloped surface 78 on each finger 64.

Each finger 64 of the open segment 40 includes an exterior side 86 that faces the stator 12, an interior side 88 that faces the field winding 34, a distal end 90 that is furthest from the cylindrical end ring 60, and a proximal end 92 that is fixedly connected to the end ring 60. Each finger 64 also includes a leading side/edge 94 and a trailing side/edge 96, with the leading edge 94 and trailing edge 96 of each finger defined by a direction of angular rotation of the rotor, as noted by arrow 98.

Web portions 68 extend between adjacent fingers 64 on the first claw pole segment 40 near the knuckle portions 66. The web portions 68 provide a smooth curved surface that extends between adjacent fingers 64. In the embodiment of FIG. 2, the surface of each web portion 68 is bounded at least in part by substantially parabolic interior and exterior perimeters. The substantially parabolic exterior perimeter provides a first vertex 82 located where the proximal end 92 of the finger is connected to the end ring 60. The substantially parabolic interior perimeter provides a second vertex 84 on the distal edge of the open segment at a point centered between adjacent fingers 64. Between the vertices 82 and 84, the smooth web surface 68 gradually transitions from the exterior surface to the interior surface.

With particular reference to FIGS. 2-4, the fingers 64 include indentations 80 along the edges of the fingers adjacent to the web portions 68. The indentations in the embodiment of FIGS. 2-4 are provided as beveled edges that form chamfers 80 on the trailing edges of the fingers 64. More specifically, each chamfer 80 is formed on the exterior side 86 of a finger 64 at the proximal end 92 of the finger, with the chamfer 80 positioned on the trailing side 96 of such finger 64. The chamfers 80 are positioned on the rotor such that each chamfer is substantially outside of the airgap region of the rotor. Accordingly, most of the chamfer 80 does not face the active airgap 24 between the stator and the rotor.

In the embodiment of FIGS. 2-4, each chamfer 80 provides a chamfered surface 81 that extends the substantial length of the web portion 68 adjacent to the chamfer 80 on the exterior trailing side of the associated finger 64. The chamfers 80 are elongated in shape with a largest chamfer dimension extending in a substantially axial direction (i.e., more in the direction of the shaft 18 than in the direction of angular rotation 98). In the embodiment of FIGS. 2-4, the larger chamfer dimension is about 20 mm and the smaller dimension is about 8 mm. In at least one embodiment, the elongated chamfer 80 has a larger chamfer dimension of about 10-60 mm and a smaller chamfer dimension of about 4-20 mm.

As illustrated FIGS. 2 and 4, the chamfered surface 81 forms an angle  $\alpha$  with a tangency line 100 defined at a point on the axial centerline of the finger 64. This angle  $\alpha$  is typically less than forty-five degrees. In at least one embodiment, the chamfered surface 81 is less than thirty degrees relative to the tangency line 100 on the exterior side of the finger 64 (i.e.,  $\alpha < 30^\circ$ ). In at least one embodiment, the chamfered surface 81 is a generally flat surface. However, it will be recognized that in other embodiments, the chamfered surface could include a surface with a compound angle or a generally a curved surface. It will also be recognized that the chamfered surface 81 may be formed in any number of ways. For example, in one embodiment, the trailing edges of the fingers initially include a compound angle. The segment is then rotated about two angles to establish the chamfer line. Once in position, the trailing edge of each finger is machined with an end mill as a straight cut. Other examples of methods for forming the

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chamfered surface include cold forming or hot forging the chamfered surface directly into the segment when it is formed.

The chamfered surface **81** results in a finger **64** that is asymmetrical in shape relative to an axial plane of symmetry. The plane of symmetry is represented in FIGS. **3** and **4** by dashed lines **102**. As illustrated in FIGS. **3** and **4**, the plane of symmetry **102** extends through an axial centerline of the finger **64** and through the axis of rotation of the rotor. When viewing the opposing sides of the finger **64** relative to this plane of symmetry **102**, it is clear that the finger **64** is asymmetrical because of the chamfer **80**. However, it will be recognized that except for the chamfer **80**, the finger **64** would be symmetrical about the plane of symmetry **102**. As explained in further detail below, the strategic location of these chamfers **80** on the trailing edges of the fingers **64** provides for an electric machine with an improved airflow arrangement.

With reference again to FIG. **2**, the second claw-pole segment **42** is also crown shaped with a plurality of fingers **74** extending from a generally closed end portion or wall **72**. Because of this end wall **72**, the second segment **42** is sometimes referred to as a "closed segment". The end wall **72** includes a small center bore that receives the shaft **18** of the alternator and allows the second segment **42** to be fixed to the shaft **18**.

The fingers **74** of the second segment **42** are interlaced with fingers **64** from the opposing first segment **40**. In particular, the fingers **74** of the second segment **42** extend toward the first segment **40** and into gaps between the fingers **64** of the first segment **40**. Likewise, the fingers **64** of the first segment **40** extend toward the second segment **42** and into gaps between the fingers **74** of the second segment **42**. As a result, the fingers **64**, **74** alternate around the center of the segments **40**, **42**. A center ring **44** connects the first segment **40** to the second segment at the center of the segments **40**, **42**. As explained in further detail below, because the fingers **64** and **74** define poles for the rotor **14**, fingers **64** and **74** may also be referred to herein as rotor "poles".

General operation of the alternator **10** is now described with reference again to FIG. **1**. When current flows through the field coil **34**, it produces a magnetic field with an N pole at one end of the field coil and an S pole at the opposite end of the field coil. The two claw pole segments **40**, **42** of the rotor **14** channel the magnetic flux produced from the field coil **34** to the appropriate surface on the stator **12**. The useful flux linkage between the stator **12** and the rotor **14** is shown in FIG. **1** by dotted lines **28**. The useful flux path **28** is in the form of a closed loop that travels through the stator **12**, the claw-pole segments **40**, **42**, the spool **36**, the rotor core **32**, and any air gaps between such components along dotted line **28**, such as air gap **38**.

Because the current in the field winding **34** is DC, one claw-pole segment is always magnetic N, and the other claw-pole segment is magnetic S. Further, because the fingers of the claw pole segments are interlaced, this result in an alternating N pole, S pole arrangement. Since the claw-pole segments **40**, **42** are attached to the rotating alternator shaft **18**, the magnetic field experienced by the stator **12** at any fixed point alternates between N and S in a cyclical or AC fashion. This rotating magnetic field induces a voltage in the stator windings. The stator windings are connected to a diode rectifier that converts the AC stator output to a DC output that is used to charge the battery and power vehicle loads. A voltage regulator monitors the system voltage and adjusts the output of the alternator by controlling the current through the field coil.

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In the embodiment of FIG. **1**, it should be noted that the open claw-pole segment **40** interfaces with the stationary portion of the core (i.e., the iron spool **36**) at air gap **38**. It is generally desirable to minimize this air gap **38** to increase performance of the alternator **10**. Consequently, the axial length of the open segment **40** is typically elongated in this region (as noted by dimension **1**) to increase the surface area at the gap **38** and increase the permeance (i.e., to reduce magnetic reluctance) of the rotor **14** in this region. Because of this, the amount of iron or other magnetic material in this region can often be more than is necessary for proper magnetic performance. Accordingly, the chamfers **80** on the open segment **40** result in reduced magnetic material on the open segment, but have minimal impact on the magnetic performance of the alternator. Indeed, as explained in further detail below, the chamfers **80** actually improve output through increased airflow through the rotor, and higher rotor excitation.

With reference now to FIG. **5**, lines **50** and **52** show exemplary cooling air streams flowing through the alternator **10** in a generally axial direction. The air streams **50**, **52** enter the alternator housing **16** through various openings in the housing. A fan **56** mounted on the shaft **18** creates low pressure within the alternator housing, thus drawing cooling air into the openings in the housing **16**. The fan **56** draws the air through the alternator, and then blows air exiting alternator **10** away from the housing **12**. Air stream **50** enters through the rear end (also referred to as the "open end") of the alternator **10**. Air stream **50** flows through the rotor **14** and over the field coil **34** before exiting out of exit port **54** at the rear of the housing **16**. Air stream **52** enters through a side opening in the housing **16** and flows over the stator windings **22** before exiting through the exit port **54**.

The generally axial flow of air through the alternator **10** is disrupted during operation of the alternator by rotation of the rotor **14** at the center of the alternator **10**. In particular, the cooling air typically enters the claw-pole alternator at or near the rear of the alternator and travels toward the front in a generally axial direction. However, in the center of the alternator is the rotor **14** that is rotating during alternator operation. Because of this rotation, air enters into openings between the fingers **64**, **74** of the claw-pole iron segments at an angle. In particular, before air can pass into the rotor **14**, it must first flow circumferentially past a rotating finger **64** of the open claw-pole segment **40**. The air must then turn after encountering an opening between the fingers, and flow in a more axial direction over the field coil at the center of the claw-pole segments. This process generally limits the flow of air through the rotor, as the change in flow momentum results in a pressure drop and generally less volume of air through the alternator.

The foregoing air flow arrangement is generally illustrated in FIGS. **6-8**, which show typical open and closed segments **40**, **42** for a conventional claw-pole rotor **14**. FIG. **6** shows an air stream "A" flowing into the rear of the alternator **10** in a generally axial direction due to the low pressure created by the fan at the front of the alternator **10**. FIG. **7** shows rotation of the rotor **14** in a direction of angular rotation "B" during operation of the alternator **10**. This direction "B" cuts across the axial direction "A". Accordingly, FIG. **8** shows that the combination of "A" and "B" results in air stream "C" which is the direction of air flow experienced by the rotor. Air stream "C" moves in a circumferential direction near the proximal ends of the fingers **64** and the end ring **60** of the open segment **40**. However, as a given rotor finger **64** passes a fixed location at the rear of the alternator, the air stream "C" will try to flow forward toward the front of the alternator due to the low

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pressure created by the fan 56 at the front of the alternator. Accordingly, the air stream “C” must make a turn at the trailing edge 96 of the finger 64, as the air stream moves from a generally circumferential flow to a generally axial flow. This turn in the air stream results in a high pressure drop at the trailing edges 96 of the fingers 64, and a general loss in momentum of airflow. The high pressure drop and loss of momentum results in a reduced volume of air flowing around the fingers and through the rotor 14. With a reduced volume of air flowing through the rotor 14, the alternator remains at a relatively higher temperature and generally experiences decreased performance ratings.

In the embodiment of FIGS. 1-4, the high pressure drop encountered at the trailing edges 96 of the fingers 64 is remedied at least in part by the chamfers 80 at the trailing edges of the fingers 64. In particular, the chamfers allow cooling air to more easily turn around the trailing edges of the fingers, resulting in little pressure drop. Because the strategic position of the chamfers 80 remedies the pressure drop issue, an increased volume of air is drawn through the alternator. This results in cooler alternator operation and increased alternator performance.

It will be recognized that the above-description of the claw-pole rotor arrangement also provides for an associated method of cooling an alternator 10. Unlike the claw-pole rotor shown in FIGS. 6-8, the disclosed method involves the use of a claw-pole rotor arrangement similar to that of FIGS. 1-4. In particular, the disclosed method involves rotation of a claw-pole segment 40, such as that shown in FIG. 2, with chamfers 80 or other indentations formed on the trailing edges of the fingers 64. According to this method, the air stream drawn in to the alternator with the fan is directed to flow over an exterior surface of a claw-pole rotor segment 40, such as the end ring 60 at the rear of the segment 40. The cooling air is then directed over the chamfers 80 on the trailing edges 96 of the fingers of the open segment 40 of the claw-pole rotor arrangement. Thereafter, the stream of air flows between the fingers 64 and 74 and over the field winding 34 positioned on the interior of the claw-pole arrangement. The air stream then exits the alternator at an opposite end of the alternator. Advantageously, this method provides for an increase volume of air through the alternator, resulting in cooler alternator operation and increased alternator performance.

The foregoing detailed description of one or more embodiments of the airflow passage arrangement for claw-pole electric machines has been presented herein by way of example only and not limitation. It will be recognized that there are advantages to certain individual features and functions described herein that may be obtained without incorporating other features and functions described herein. Moreover, it will be recognized that various alternatives, modifications, variations, or improvements of the above-disclosed embodiments and other features and functions, or alternatives thereof, may be desirably combined into many other different embodiments, systems or applications. Presently unforeseen or unanticipated alternatives, modifications, variations, or improvements therein may be subsequently made by those skilled in the art which are also intended to be encompassed by the appended claims. Therefore, the spirit and scope of any appended claims should not be limited to the description of the embodiments contained herein.

What is claimed is:

1. A method of cooling an electric machine using a stream of air flowing through the electric machine, the electric machine having a claw-pole rotor arrangement with an active airgap defined between the claw-pole rotor arrangement and

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a stator core, the claw-pole rotor arrangement including an open claw-pole segment and a closed claw-pole segment, the method comprising:

- rotating the claw-pole rotor arrangement in a direction of angular rotation about an axis of rotation;
- receiving a stream of air into a first end of the electric machine such that the stream of air flows over an exterior surface of the claw pole rotor arrangement;
- causing the stream of air to flow over an indentation on a trailing edge of a proximal end of a finger of the claw-pole rotor arrangement, the indentation not extending to a distal end of the finger or a leading side of the finger, the finger being asymmetrical in shape relative to a plane extending through an axial centerline of the finger and through the axis of rotation, and wherein most of the indentation does not face the active airgap; and
- causing the stream of air to flow between fingers on opposing segments of the claw-pole rotor arrangement and over a field winding positioned on the interior of the claw-pole arrangement.

2. The method of claim 1 further comprising causing the stream of air to exit the electric machine at a second end of the electric machine.

3. The method of claim 2 wherein causing the stream of air to flow over the indentation, causing the stream of air to flow between the fingers, and causing the stream of air to exit the electric machine are all accomplished using a fan positioned on the second end of the electric machine.

4. The method of claim 3 wherein the indentation is a chamfer positioned adjacent to a web portion extending between adjacent fingers of the claw-pole arrangement, and wherein the chamfer is elongated in shape having a substantially longer dimension in an axial direction than in a circumferential direction.

5. A method of cooling an electric machine comprising a rotor and a stator core, the rotor separated from the stator core by an airgap in an active airgap region of the rotor, the method comprising:

- rotating the rotor about an axis of rotation in a direction of angular rotation, the rotor including a first claw-pole segment and an opposing second claw-pole segment, the first claw-pole segment including a plurality of fingers extending in an axial direction from an end ring, each finger including (i) a distal end and a proximal end with the proximal end fixed to the end ring, (ii) an interior side and an exterior side, the exterior side facing the stator, and (iii) a leading side and a trailing side defined by the direction of angular rotation, and (iv) an indentation on the exterior trailing side of the finger at the proximal end of the finger and substantially outside of the active airgap region of the rotor, the exterior leading side of the finger void of an additional chamfer that is symmetric to the chamfer formed on the exterior trailing side of the finger, and the indentation on the exterior trailing side of the finger not extending to the exterior leading side of the finger; and

receiving a stream of air into a first end of the electric machine such that the stream of air flows over an exterior surface of the end ring of the first claw pole segment, over the indentation on the exterior trailing side of each finger, between alternating fingers on the first claw pole segment and the second claw-pole segment, and over a field winding positioned on the interior of the first claw-pole segment and the second claw-pole segment.

6. The method of claim 5 wherein each finger is asymmetrical in shape relative to a plane of symmetry extending through an axial centerline of the finger and through the axis of rota-

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tion of the rotor, wherein the asymmetrical shape of the finger results from the indentation such that the finger is substantially symmetrical except for the indentation.

7. The method of claim 5 wherein a knuckle portion is positioned at the proximal end of the finger with the indentation on the finger extending from the end ring to the knuckle portion.

8. The method of claim 5 wherein the first claw pole segment further includes a web portion extending between adjacent fingers at the proximal ends of the fingers.

9. The method of claim 8 wherein the indentation on the trailing edge of each finger is provided as a surface adjacent to the web portion.

10. The method of claim 9 wherein the surface adjacent to the web portion is a chamfered surface that extends the substantial length of the web portion on the exterior trailing side of the finger.

11. The method of claim 5 wherein the indentation is elongated in shape with a largest indentation dimension extending in a substantially axial direction.

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12. The method of claim 5 wherein the indentation is provided as a chamfered surface that is less than forty-five degrees relative to a tangency line on the trailing edge of the finger.

13. The method of claim 12 wherein the chamfered surface is less than thirty degrees relative to the tangency line on the trailing edge of the finger.

14. The method of claim 5 wherein the first claw pole segment and the second claw pole segment are connected by an interior ring.

15. The method of claim 14 wherein the rotor includes a rotor core connected to a shaft, and wherein the second claw pole segment is connected to the shaft and the rotor core.

16. The method of claim 5 wherein the field winding is positioned on a spool located inside of the first claw pole segment and the second claw pole segment.

17. The method of claim 5 wherein the first claw-pole segment is an open claw-pole segment and the second claw-pole segment is a closed claw-pole segment.

18. The method of claim 5 wherein the electric machine is an alternator used in association with a vehicle.

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